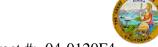
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-004163 Address: 333 Burma Road **Date Inspected:** 20-Oct-2008

City: Oakland, CA 94607

OSM Arrival Time: 2230 **Project Name:** SAS Superstructure **OSM Departure Time:** 730 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes No **Inspected CWI report:** N/A **Rod Oven in Use:** Yes Yes No No N/A **Electrode to specification:** Yes No N/A Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No N/A **Verified Joint Fit-up:** Yes No N/A N/A **Approved Drawings:** Yes No N/A **Approved WPS:** Yes No Yes N/A **Delayed / Cancelled:** No

34-0006 **Bridge No: Component:** OBG

Summary of Items Observed:

OBG

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island

	Description	WBS	Dwg No.	Status
1	Side Plate	NA	NA	QA-UT

Bay 3: Caltrans QA inspector performed ultrasonic test (UT) inspection per ZPMC notification of witness inspection, document number 001247. The OBG side plate subassembly identified as side plate welds, SP156-001-055, SP369-001-055, SP342-001-055, SP129-001-055 and SP102-001-064. Caltrans QA inspector observed that ZPMC QC-UT inspector, Mr. Xu Rong Gang tested and accepted welds SP156-001-055 and SP342-001-005, Mr. Wu Hai Long tested and accepted SP369-001-055, SP129-001-055 and SP102-001-064. Caltrans QA inspector UT weld coverage was approximately ten-percent. The welds appeared to be in conformance with the project specifications. See Caltrans Ultrasonic Test Report (TL-6027) dated October 20, 2008 for additional information.

Floor Beam NA NA OA-UT 2 Bay 7: Caltrans QA inspector performed ultrasonic test (UT) inspection per ZPMC notification of witness inspection, document number 001245. The OBG diaphragm subassembly welds are identified as FB011-010-045, FB009-013-045 and FB009-014-045. Caltrans QA inspector observed that ZPMC QC-UT inspector, Mr. Xue Hai

Yang tested and accepted welds. Caltrans QA inspector UT weld coverage was approximately ten-percent. The welds appeared to be in conformance with the project specifications. See Caltrans Ultrasonic Test Report (TL-6027) dated October 20, 2008 for additional information. The following digital picture illustrates typical inspected floor beam

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

weld.



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler,Mike	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer